

Date: Monday, 8/21/2006 2:11:09 PM
 User: Kim Johnston

Process Sheet

| | | | |
|-----------------------|---|------------------|---------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : WEARPAD |
| Job Number | : 28249 | | |
| Estimate Number | : 10313 | | |
| P.O. Number | : <i>N/A</i> | Part Number | : D26483 |
| This Issue | : 8/21/2006 | Drawing Number | : D2648 REV D |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : <i>N/A</i> | Drawing Revision | : D |
| Previous Run | : 28123 | Material | : <i>N/A</i> |
| Written By | : <i>[Signature]</i> | Due Date | : 9/5/2006 |
| Checked & Approved By | : <i>[Signature]</i> | Qty: | <i>202</i> Um: Each |
| Comment | : Est: E 02.09.18 Re-format; Incorporated D2648-1 KJ/RF Est Rev:F Now on Waterjet 06-08-14 JLM | | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|------------|-------------------------|
| 1.0 | M1010S16GA | 1010/1025/A21/6aA SHEET |
|-----|------------|-------------------------|



Comment: Qty.: 0.0788 sf(s)/Unit Total : 15.7500 sf(s)
 1010/1025/A21/6aA SHEET
 (M1010S16GA)
 Batch: *M1010S16GA* *M1010S16GA*

| | | |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



Comment: FLOW WATER JET
 1-Cut as per Dwg D2648
 *****CUT WITH FILE D2648-1*****
 Dwg Rev: *D*
 Prog Rev: *D*
 2-Deburr if necessary

M1010S16GA *06-08-28* Not Deburred
SAD *06-08-28*

(202)

| | | |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD *06-08-28*

| | | |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

06-08-28 *202*
Counted

| | | |
|-----|-------------|-------------------------------|
| 5.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|



Comment: SMALL & MEDIUM FAB RESOURCE 1
 Deburr if necessary

SAD *06-08-28*

202

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 04/21/11

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 8/21/2006 2:11:10 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 28249

Part Number: D26483

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Form as per Dwg D2648 on CNC brake using Jigs DT 8261 and DT 8326.

SAD 06/09/20

(202)

2-Identify as D2648-3

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description

Batch

A/R560Hardcoat

M100294, M102756

1-Weld as per Dwg D2648 using Jig DT 8210

2-Remove any weld that penetrated through Wearpadif necessary

MF.

06-11-28

(202)

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

11/06/11/28

(202)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

11/06/14/28

(202)

10.0

POWDER COATING

POWDER COATING



M 101601



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M-2/4/06/12/15

(202)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FC

06/12/19

(202)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: F017

FC

06/12/19

(202)

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

(202)

06/12/19

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries.

QA: N/C Closed: _____ Date: _____

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

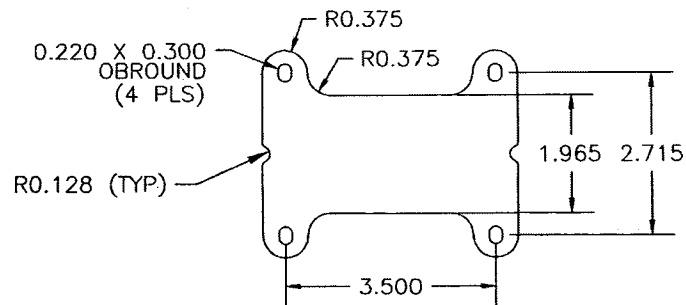
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| | | | | | | | | |
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| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

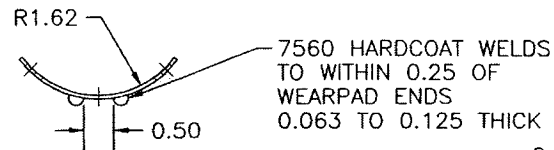
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

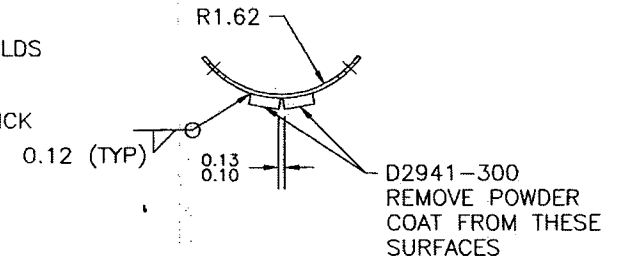
D2648-1 FLAT PATTERN



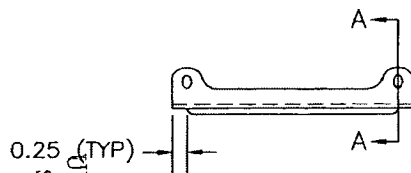
SECTION A-A



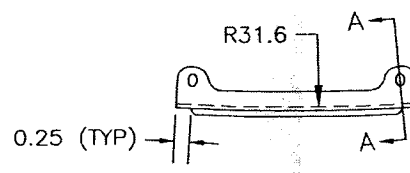
SECTION B-B



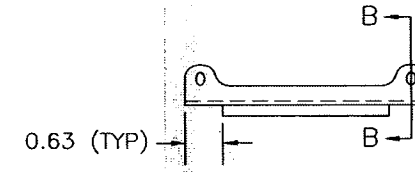
D2648-3 LONGITUDINAL BEND (MADE FROM D2648-1)



D2648-5 LONGITUDINAL BEND (MADE FROM D2648-1)



D2648-7 LONGITUDINAL BEND (MADE FROM D2648-1)



RELEASED
99.12.20 DS



NO. 28249
WORK ORDER
SUBJECT TO AMENDMENT
WITHOUT NOTICE
UNCONTROLLED
ENGINEERING
RETURN TO
SHOP COPY

BREAK ALL SHARP CORNERS 0.063 MAX
MATERIAL: 16 GAUGE AISI 1010-1025 OR ASTM A36/A366 STEEL (0.063 THICK)
FINISH: POWDER COAT GREY (REF. 4.3.5.5) PER DART QSI 005
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

| | | |
|----------|----------|--|
| D | 99.11.17 | ADDED D2648-7 |
| C | 97.06.26 | R31.6 WAS R19.6 |
| B | 97.05.30 | ENLARGE OBROUND, 0.375 WAS 0.250 |
| A | 97.03.25 | NEW ISSUE |
| DESIGN | DRAWN BY | DART DART AEROSPACE USA, INC. BOLLENE, WA |
| CHECKED | APPROVED | DRAWING NO. D2648 |
| DATE | TITLE | SCALE |
| 99.11.17 | WEARPAD | 1:2 |

